

Date: Thursday, 16/08/2007 10:31:33 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Jot Number : 34010 -2
Est mate Number : 10794
P.C. Number : N/A
This Issue : 16/08/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 32892
Written By :
Checked & Approved By :
Comment : Est Rev A 05.10.14 New issue KJ/EC

Drawing Name : TOW RING
Part Number : D3407041
Drawing Number : D3407 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 02/09/2007 Qty: 12 Um: Each

Additional Product

Jot Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34071	Stem
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3407-1 Stem B 32898	
2.0	D34075	Ring
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3407-5 Ring B 34708	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004 A/R TIG174 ROD Batch: M 18774	
4.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	
5.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	

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Drawing Name: TOW RING

Job Number: 34010

Part Number: D3407041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask Threaded Section

m 105914

BL

07-11-01

(9)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/11/1

SP (10X)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/11/1

SP (10X)

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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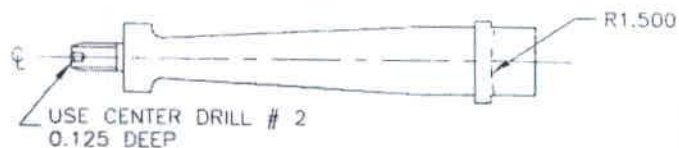
Comment: FINAL INSPECTION/W/O RELEASE

(R)
2011/10

Job Completion

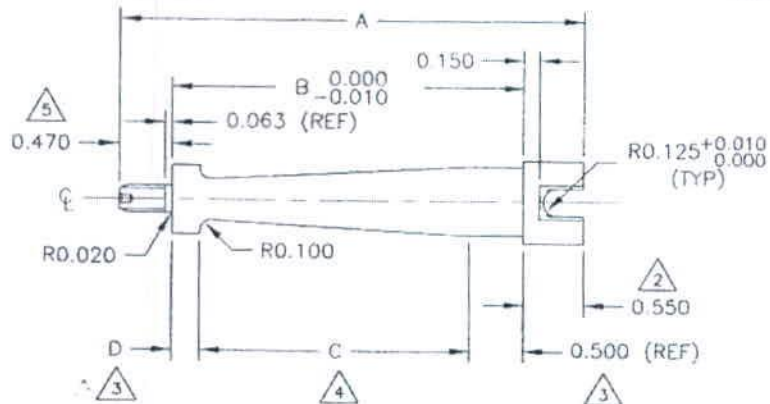


U 07.11.02



RELEASED

05 04.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

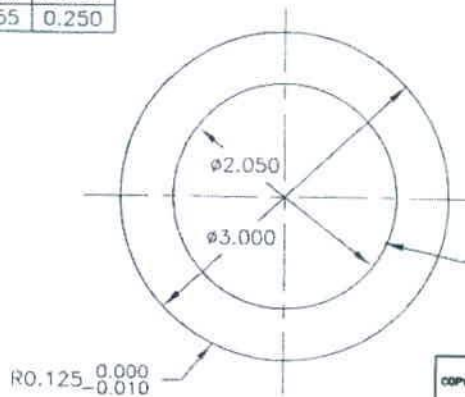
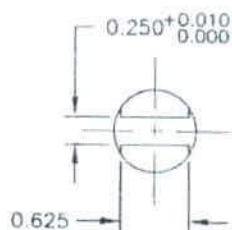
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

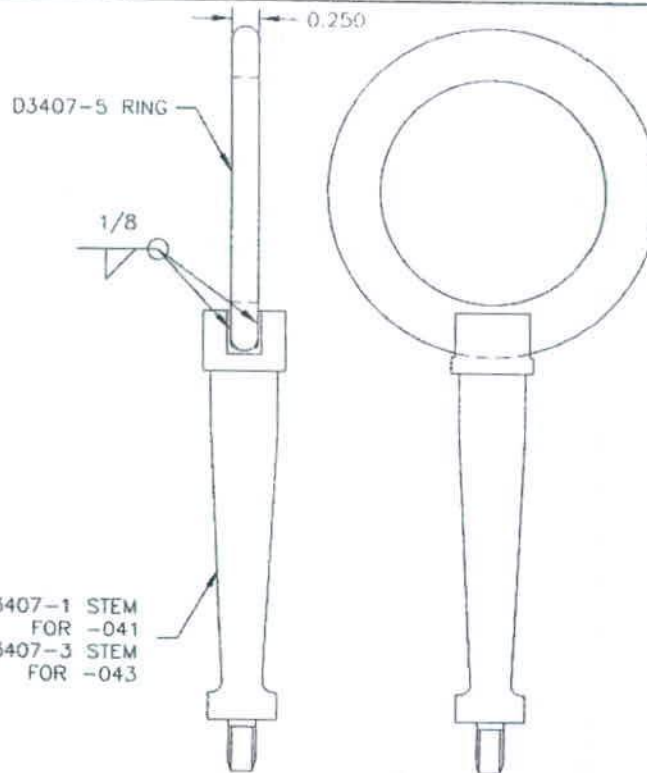
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3407-5 RING



USE D3407-1 STEM
FOR -041
USE D3407-3 STEM
FOR -043

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	#	APPROVED #
DATE	05.09.09	DRAWING NO. D3407
		TITLE TOW RING

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PORT HADLOCK, MA

REV. 0
SHEET 1 OF 1
SCALE 1:1

Handwritten signature/initials

